

# Work Order ID 73215

Friday, August 26, 2011 10:25:15 AM



Page 1

Item ID: D3574-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/08/26 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3574	Rev B

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3574 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

B11-9-29

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-9-29

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulor/29

(x2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73215**

Friday, August 26, 2011 10:25:15 AM



Page 3

Item ID: D3574-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/3

CME 11-09-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 26, 2011 10:25:12 AM

Page 1

Work Order ID: 73215



Parent Item: D3574-2



Parent Item Name: Cabin Floor Protector

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	1,229.178		67.23362			
GE PLASTICS LEXAN SHEET													

Bil-4-29

Location

Loc Qty

Loc Code

MAT018

1229.178289

116236

1229.17829

116 236

(2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	73215
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-2
<b>Inspection Dwg:</b> D3574 <b>Rev:</b> B		<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.004	X		V HB02	
7.37	+/-0.030	7.37	X		T B01	
10.75	+/-0.030	10.75	X		T	
11.00	+/-0.030	11.00	X		T	
15.25	+/-0.030	15.25	X		T	
25.87	+/-0.030	25.87	X		T	
39.75	+/-0.030	39.75	X		T	
44.75	+/-0.030	44.75	X		T	
53.51	+/-0.030	53.51	X		T	
63.50	+/-0.030	63.50	X		T	
65.25	+/-0.030	65.25	X		T	
10.75	+/-0.030	10.75	X		T	
11.00	+/-0.030	11.00	X		T	
14.75	+/-0.030	14.75	X		T	
25.50	+/-0.030	25.50	X		T	
25.75	+/-0.030	25.75	X		T	
26.00	+/-0.030	26.00	X		T	
32.87	+/-0.030	32.87	X		T	
38.81	+/-0.030	38.81	X		T	
45.00	+/-0.030	45.00	X		T	
48.25	+/-0.030	48.25	X		T	
58.38	+/-0.030	58.38	X		T	
61.25	+/-0.030	61.25	X		T	
64.13	+/-0.030	64.13	X		T	
64.63	+/-0.030	64.63	X		T	
66.50	+/-0.030	66.50	X		T	
7.50	+/-0.030	7.50	X		T	
9.50	+/-0.030	9.50	X		T	
10.38	+/-0.030	10.38	X		T	
10.88	+/-0.030	10.88	X		T	
14.50	+/-0.030	14.50	X		T	
16.56	+/-0.030	16.56	X		T	
18.75	+/-0.030	18.75	X		T	
24.13	+/-0.030	24.13	X		T	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	73215
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-2
<b>Inspection Dwg:</b> D3574 <b>Rev:</b> B		<b>Page 2 of 2</b>	

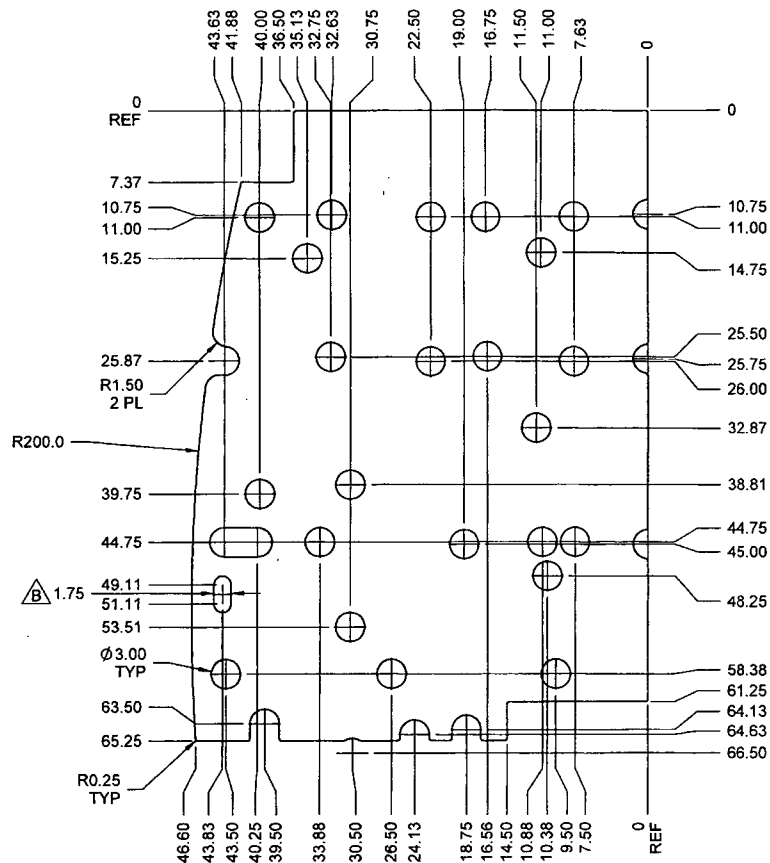
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.50	✓		T K301	
30.50	+/-0.030	30.50	✓		T	
33.88	+/-0.030	33.88	✓		T	
39.50	+/-0.030	39.50	✓		T	
40.25	+/-0.030	40.25	✓		T	
43.50	+/-0.030	43.50	✓		T	
46.60	+/-0.030	46.60	✓		T	
7.63	+/-0.030	7.63	✓		T	
11.00	+/-0.030	11.00	✓		T	
11.50	+/-0.030	11.50	✓		T	
16.75	+/-0.030	16.75	✓		T	
19.00	+/-0.030	19.00	✓		T	
22.50	+/-0.030	22.50	✓		T	
30.75	+/-0.030	30.75	✓		T	
32.63	+/-0.030	32.63	✓		T	
32.75	+/-0.030	32.75	✓		T	
35.13	+/-0.030	35.13	✓		T	
36.50	+/-0.030	36.50	✓		T	
40.00	+/-0.030	40.00	✓		T	
41.88	+/-0.030	41.88	✓		T	
43.63	+/-0.030	43.63	✓		T	
0.125	+/-0.010	0.130	✓		V K302	

<b>Measured by:</b> RB	<b>Audited by:</b> J	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-9-09	<b>Date:</b> 11/09/09	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	



**D3574-1 CABIN FLOOR PROTECTOR**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73315

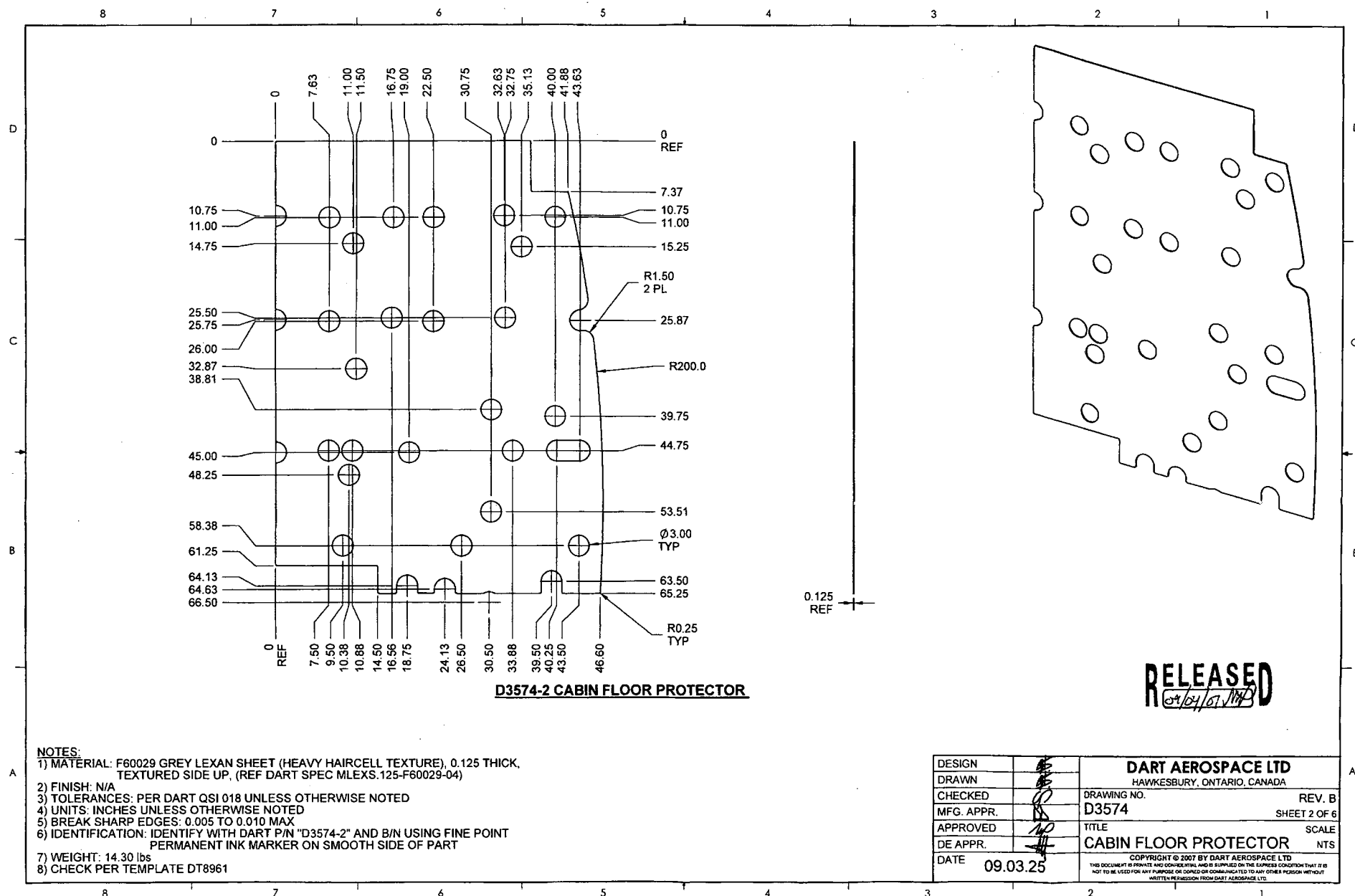
**RELEASED**  
09/03/25

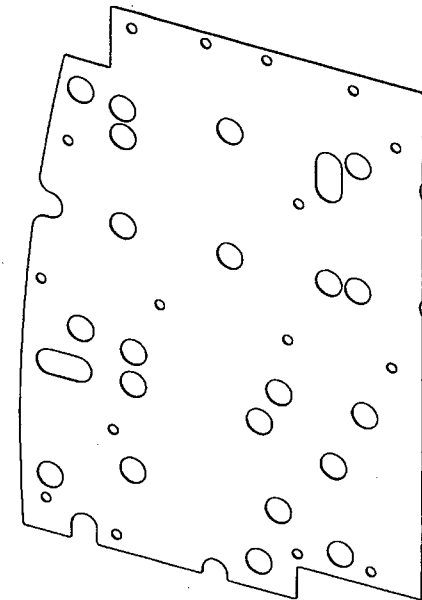
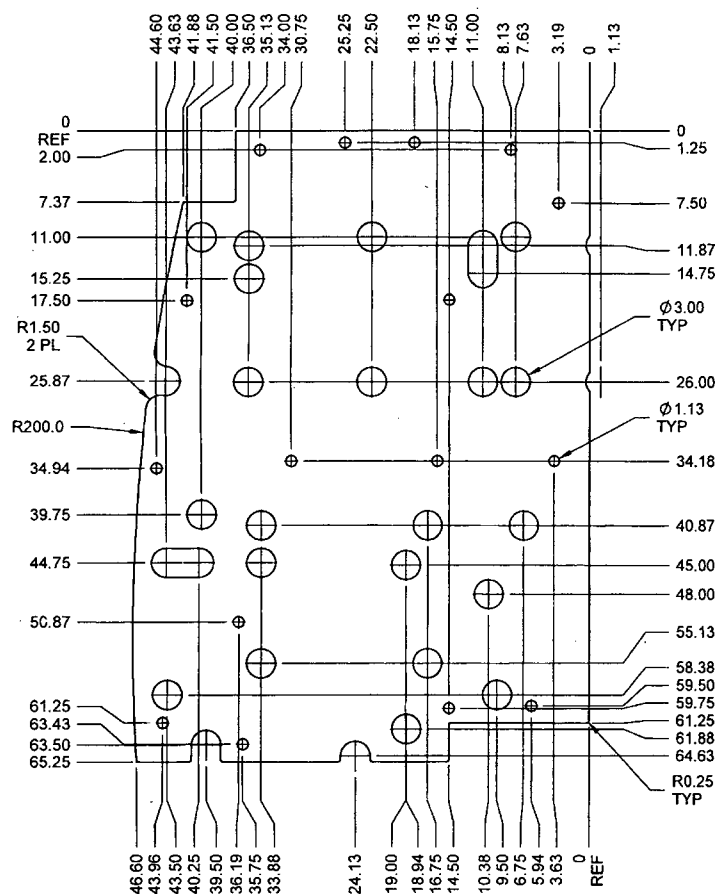
B	ADD CUT-OUT TO -1/4" FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3574** REV. B  
SHEET 1 OF 6  
TITLE **CABIN FLOOR PROTECTOR** SCALE NTS

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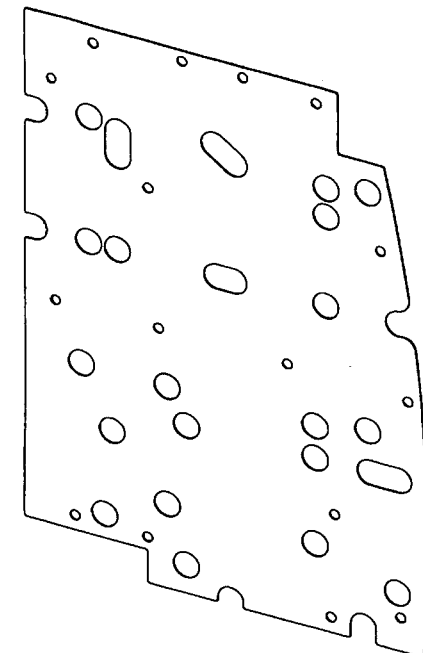
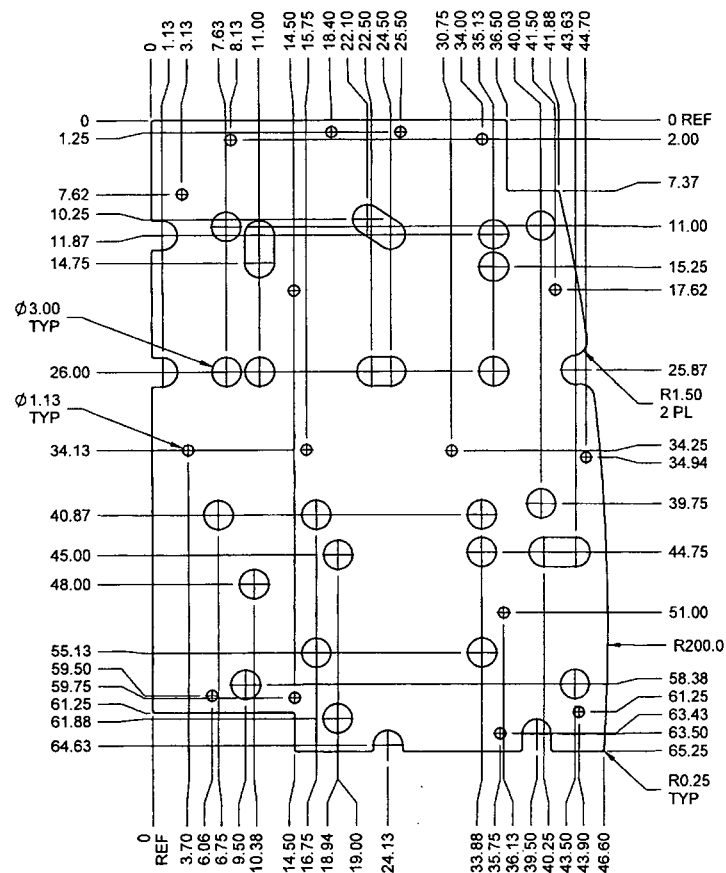
### D3574-3 CABIN FLOOR PROTECTOR

#### NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.33 lbs
- 8) CHECK PER TEMPLATE DT8962

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3574</b>	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>CABIN FLOOR PROTECTOR</b>	NTS
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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**RELEASED**  
09/07/07



**D3574-4 CABIN FLOOR PROTECTOR**

**RELEASED**  
08/07/07

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.18 lbs
- 8) CHECK PER TEMPLATE DT8963

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3574</b>	REV. B
MFG. APPR.			SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>CABIN FLOOR PROTECTOR</b>	NTS
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